

Work Order ID 84605

84605

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Thursday, May 17, 2012 10:05:10 AM

Item ID: D4151-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Fwd Hardpoint Assembly, Upper
 Start Date: 5/17/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/23/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MC Date: 12-05-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr.
D4151	C

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location <u>81 103</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

4x 12/05/12
4
4x SP
12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/5/22 JF

ME
12-05-22

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84605

Parent Item: D4151-043

Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 5/17/2012

Required Date: 5/23/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
revC DD verf:JLM

IPP Rev:C 11.01.21 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-3 Upper Hardpoint Plate		Manufactured	No			100	Each	26.0000	2	8		5/12/05/17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST103		26							
				82047		10		8					
				83459		16							
D4151-7 Fwd Eyebolt Receiver (Upper)		Manufactured	No			100	Each	0.0000	1	4		5/12/05/17	
AN4C13A BOLT		Purchased	No			100	Each	60.0000	2	8		5/12/05/17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST357		60							
				120187		1							
				121444		34		8					
				121556		25							
MS21043-4 Nut		Purchased	No			100	Each	1,522.0000	2	8		5/12/05/17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		40							
				104603		40							
				ST301		1482							
				119546		181		8					
				121162		801							
				121652		500							

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Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 5/17/2012

Required Date: 5/23/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

4,244.0000

4

16

Washer

Location

Loc Qty

Loc Code

ST297

1280

117291

280

119124

1000

ST298

2964

121255

2964

16

SP 5/2/17

Thursday, May 17, 2012 10:05:09 AM

Shop Packet Print

Page 2

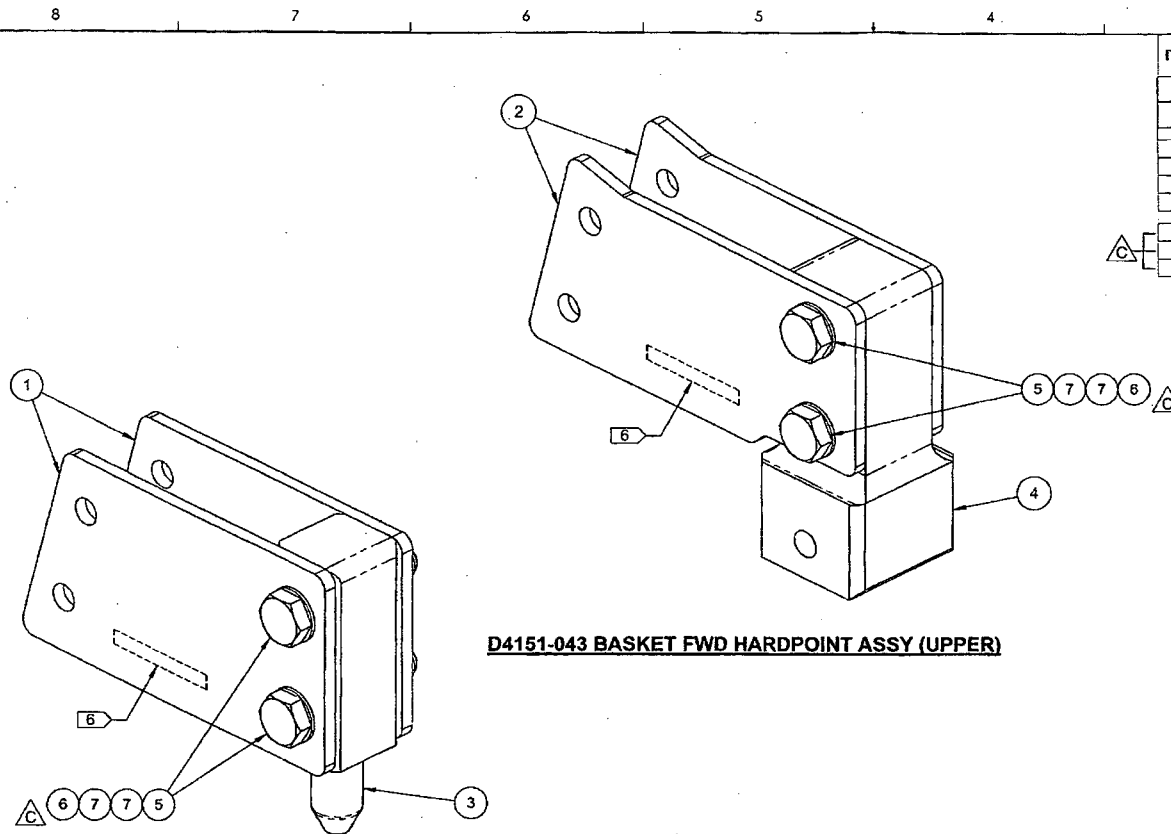
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D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

#84605

RELEASED
2011-01-08

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5SD. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED	VP		
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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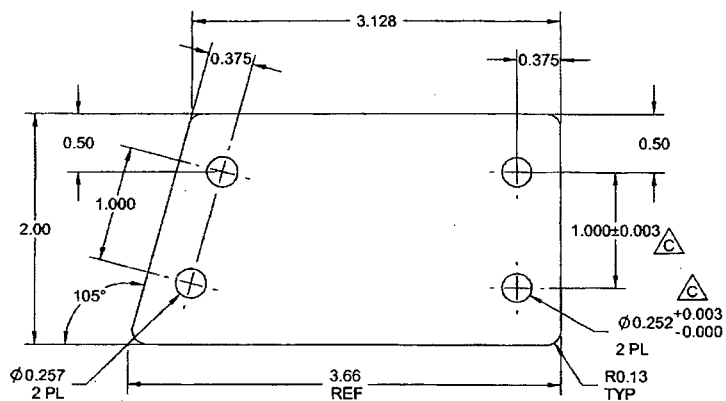
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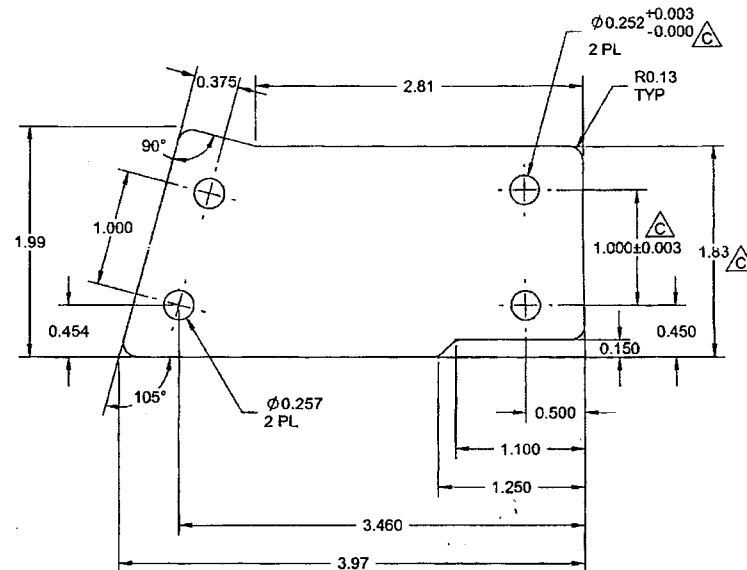
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0.125
REF

D4151-1 LOWER HARDPOINT PLATE



0.125
REF

D4151-3 UPPER HARDPOINT PLATE

NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-3 = 0.23 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	SC	DRAWING NO. D4151 REV. C
MFG. APPR.		SHEET 2 OF 3
APPROVED	NTS	TITLE BASKET FWD HARDPOINT SCALE
DE APPR.		NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD
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84605
RELEASED
2011-01-18
JMD

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